

Date: Monday, 10/16/2006 1:56:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CHAFING SHIELD
 Job Number : 28998
 Estimate Number : 11138
 P.O. Number : N/A Part Number : D31901
 This Issue : 10/16/2006 S.O. No. : N/A Drawing Number : D3190 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Due Date : 11/2/2006 Qty: 8 Um: Each
 Written By : JA
 Checked & Approved By : JA 06 10 16
 Comment : Est. A 03.05.26 New issue KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S25GA 304/316 .020" Sheet



Comment: Qty.: 0.2261 sf(s)/Unit Total : 1.8085 sf(s)

304/316 SS .020" Sheet

Material: AISI 304/316 SS 0.020" thick sheet
 (M304S25GA) Batch: 102326

FF 06-10-24 8

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 9.25" x 3.13"

Grind corner as per Dwg D3190

Deburr

Roll as per Dwg D3190

FF 06-10-24 8

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 06/10/26 8

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 413

JB 06/10/26 8

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C 10/10/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3190-1 PAR #: N/A Fault Category: Prod / Fin ASS meas & SMT NCR: Yes No DQA: Yes Date: 06/10/30
 QA: N/C Closed: Yes Date: 06.10.30

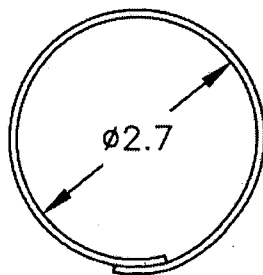
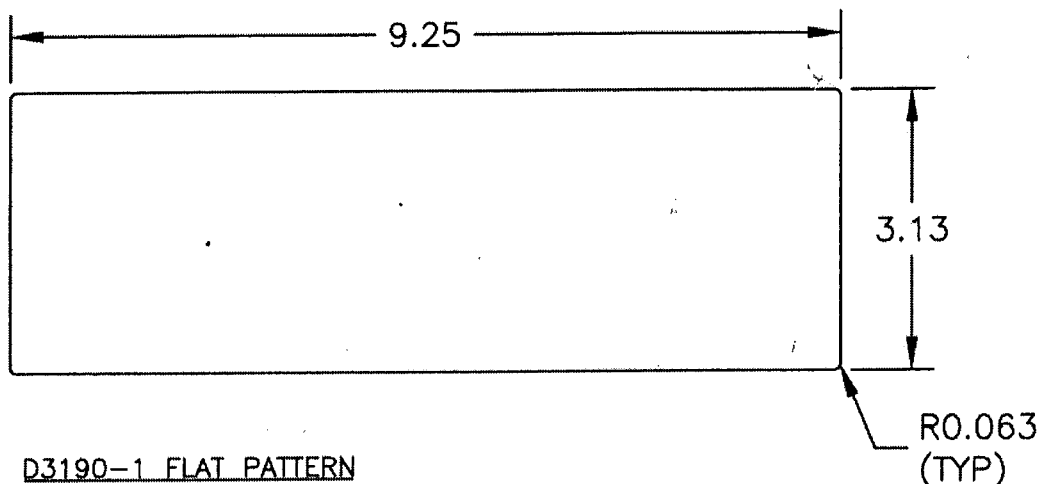
NCR: <u>28998</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-24	20	Employee used 20ga material by mistake instead of 220 mat'l. Human Error	<i>[Signature]</i>	Remind employee to measure material as per Dwg in " Specify Qty of 2 rolled parts: re-stock and I.D. remaining material. Replace parts: Qty with proper thickness	FF 06/10/24 SB	06/10/27	<i>[Signature]</i>	<i>[Signature]</i> 06-10-24

NOTE:- Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

RELEASED
03.05.22 #



D3190-1 ROLLING DETAIL
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28998

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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